

Work Order ID 60920

Monday, July 26, 2010 3:32:55 PM

Page 1

Item ID: D3852-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly

Start Date: 7/26/2010 Start Qty: 2.00

Required Date: 8/3/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MDate: 10-7-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1- pick D3166-3 to cut D3852-2 rib (RH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-2 using DT9439 jig and open to finish size as per dwg D3852

3- c/sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: M109213

7- grind bushing weld flush as per dwg dwg D3852

8- deburr hole if necessary

② Cpl 10-07-28

SAD 10-07-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start

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Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

② PD 10.07.29

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/29

④2

-042

150

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

8/10

10-07 29

②

W/O:		WORK ORDER CHANGES						
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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/29 AG
B/10-729
②

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 3:32:59 PM

Page 1

Work Order ID: 60920

Parent Item: D3852-042

Parent Item Name: Rib Assembly



Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3166-3		Manufactured	No			100	Each	10.5682	0.18	0.378947			
Basket Hoop													

Location	Loc Qty	Loc Code
WA	10.56822105	
55697	2.1053E-05	
59266	4.5682	
60270	6	

SAD 10-07-07

0.378947

D3759-1		Manufactured	No			100	Each	91.0000	1	2			
Bushing													

Location	Loc Qty	Loc Code
WA	91	
54072	9	
60241	40	
60719	42	

Pl 10-07-08

2

W/O:		WORK ORDER CHANGES					
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8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



D3852-041 RIB ASSEMBLY



D3852-042 RIB ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60920
B/10-7-26

RELEASE
EST/18 MP

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.83 lbs EACH
 8) WELDING: PER QSI 004

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.07		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA
 DRAWING NO. D3852
 TITLE RIB ASSEMBLY
 REV. A
 SHEET 1 OF 3
 SCALE NTS

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8 7 6 5 4 3 2 1

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

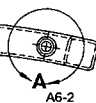
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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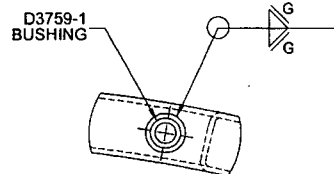


D3852-1
RIB

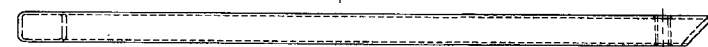


A6-2

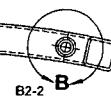
D3852-041 RIB ASSEMBLY



DETAIL A
SCALE 2X C5-2

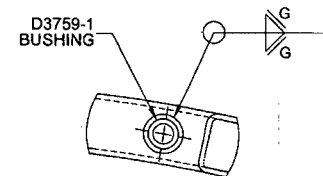


D3852-2
RIB



B2-2

D3852-042 RIB ASSEMBLY



DETAIL B
SCALE 2X C2-2

W/O 60920

RELEASED
08/11/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>125</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>125</i>	D3852	SHEET 2 OF 3
APPROVED	<i>125</i>	TITLE	SCALE
DE APPR.	<i>125</i>	RIB ASSEMBLY	NTS
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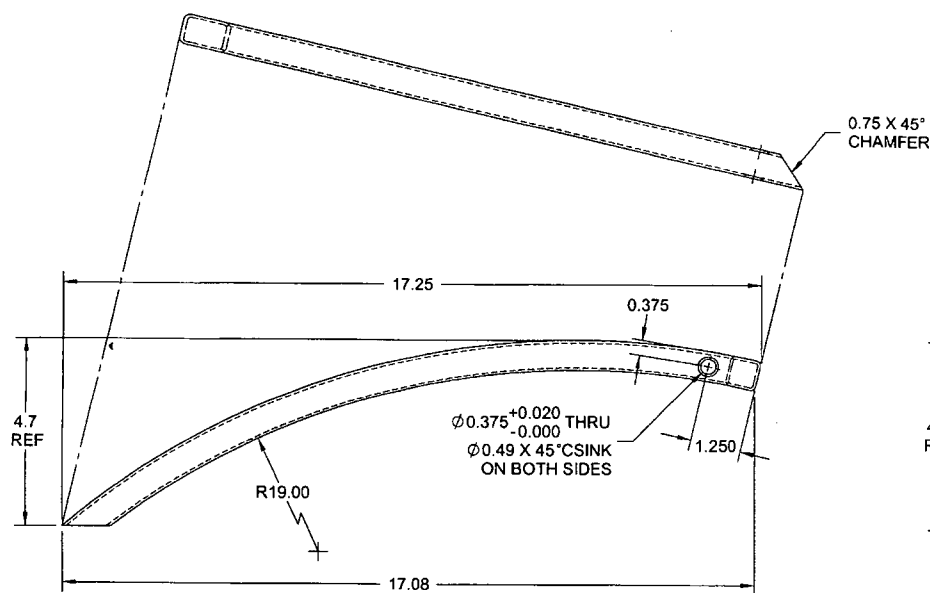
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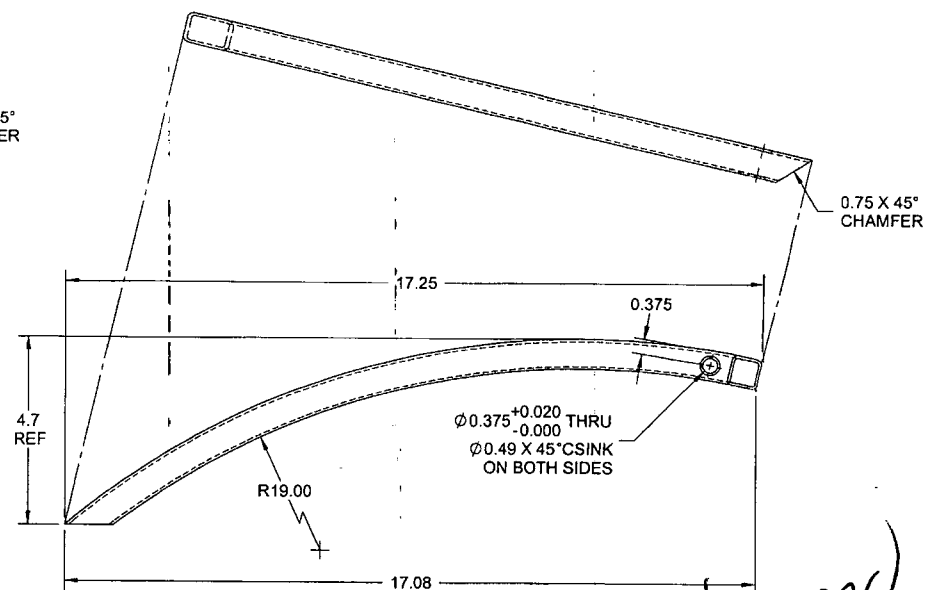
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NOTE: Date & initial all entries



D3852-1 RIB



D3852-2 RIB

who wrote

RELEASED
08/11/07

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3852	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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